












Date: Friday, 24/10/2008 3:32:08 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRONT INBOARD LEG
Job Number : 42959	
Estimate Number : 13375	
P.O. Number :	Part Number : D37681
This Issue : 24/10/2008 S.O. No. :	Drawing Number : D3768 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 40972	Material :
Written By :	Due Date : 03/11/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08-10-24</u>	
Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-25 Rev B Added Drilling tooling JLM Verified By:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6T1000W065 6061T6 RD TUBE 1.00 x .065w
	 
Comment: Qty.: 0.8969 f(s)/Unit Total: 8.9691 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M109760</u> <u>09/01/05</u> (10) M-1	
2.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-CUT TUBE TO LENGH AS PER DWG D3768 2-DRILL TUBE USING DT9044 AND AS PER DWG D3768 3-DEBURR <u>09/01/13</u> (10) M-1 <u>09/01/13</u> (10) M-1 <u>09/01/05</u> (10) M-1	
3.0	QC5 INSPECT WORK TO CURRENT STEP
	 
Comment: INSPECT WORK TO CURRENT STEP <u>09/01/13</u> (10)	
4.0	HAND FINISHING1 HAND FINISHING RESOURCE #1
	 
Comment: HAND FINISHING RESOURCE-#1 Chemical Conversion Coat as per QSI 005 4.1 <u>09 01 16</u> (10)	
5.0	POWDER COATING POWDER COATING
	 
Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 <u>09/01/19</u> (10)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D37681 PAR #: N/A Fault Category: Prod / P.B. ass. med NCR: Yes No DQA: ID Date: 09/01/23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ID Date: 09/01/23

NCR: <u>42959</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/06	#20	During inspection it was found that Qty (8) parts have one hole, ovalized from 0.333" to 0.360". (dim should be 0.333" to 0.360").	RA 09.01.02 09.01.08	Scrap and Destroy and replace Qty (8) M# 108961	M-A 09/01/13	S 09/01/13	RA 09.01.02 09.01.08	S 09/01/08
		0.323" to 0.360" R.C. improper drilling procedure and new employee. (Training).		ensure employee is shown proper drilling techniques.	FF 09/01/13	S 09/01/13 (Saw Trains Log)		S 09/01/08

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT INBOARD LEG

Job Number: 42959

Part Number: D37681

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

2:30

OVEN TEMPERATURE:

320°

FINISH TIME:

3:00

FL 09/01/19 (10)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.m 09.01.20 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 249

9/1/20

(10)

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21

Job Completion



U 09.01.20

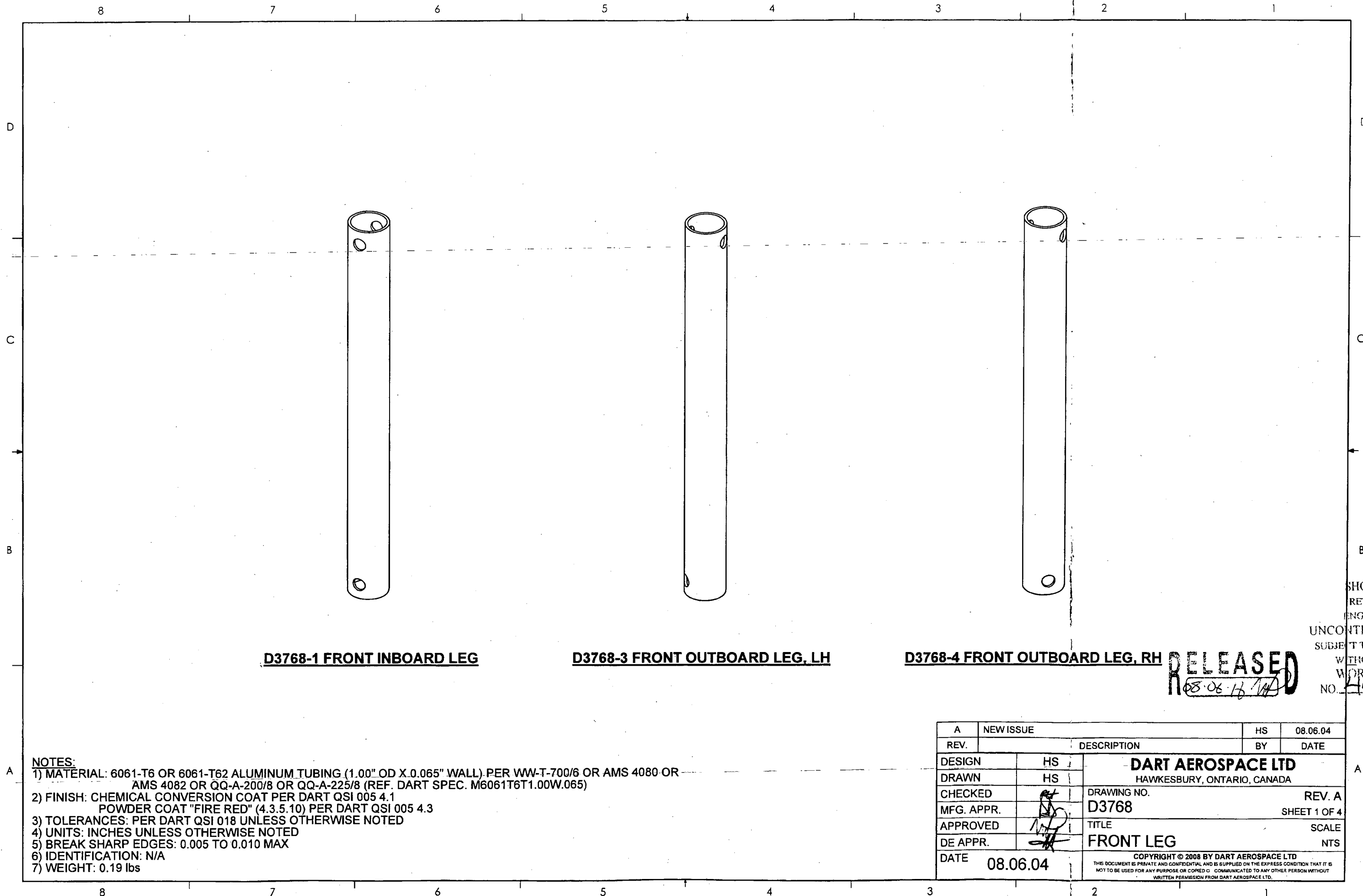
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3768-1 FRONT INBOARD LEG

D3768-3 FRONT OUTBOARD LEG, LH

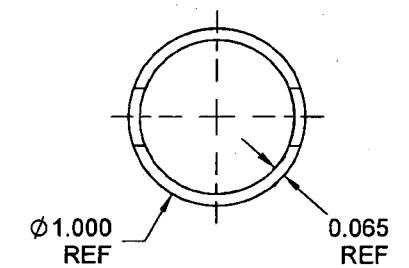
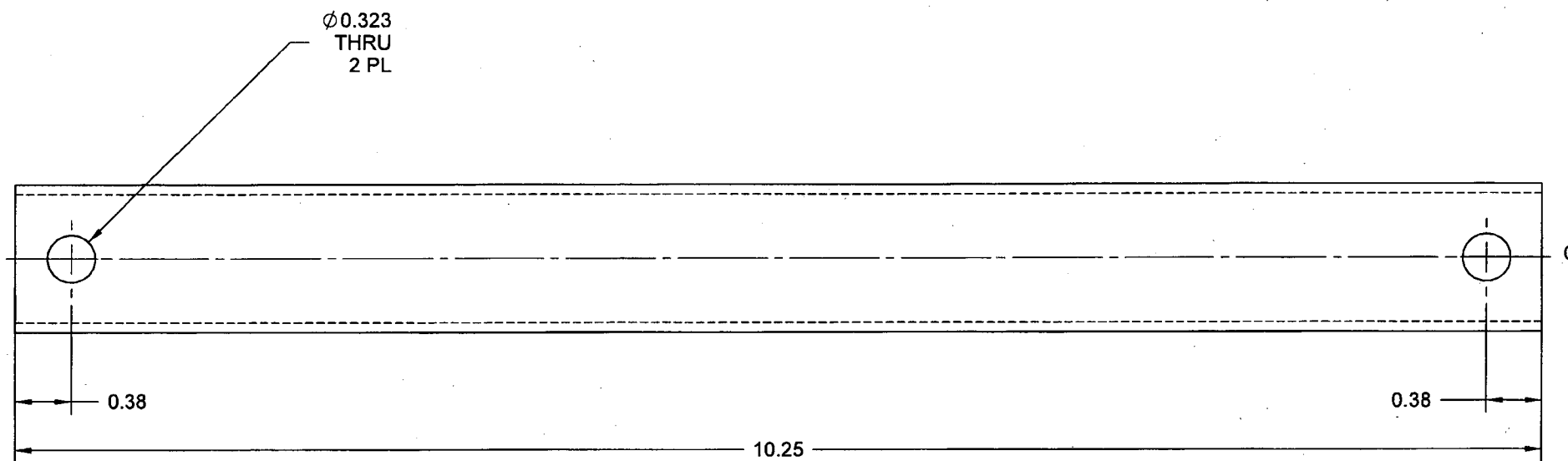
D3768-4 FRONT OUTBOARD LEG, RH

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08.06.04

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NO. 46859

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER VVV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.19 lbs

A	NEW ISSUE	HS	08.06.04
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D3768-1 FRONT INBOARD LEG

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